

Work Order ID 131929

Tuesday, April 21, 2015 1:57:06 PM

131929

Page 1

Item ID: D206-559-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Series/407 Bearpaws
 Start Date: 4/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/20/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MUS Date: 15-04-22 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-559	rev L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-559-013 CHG006								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

MAY 07 2015

DAS
65
9-89

2

MAY 06 2015

MAY 04 2015

DAS
27
9-89

MAY 07 2015

DAS
65
9-89

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 131929

Tuesday, April 21, 2015 1:57:06 PM

131929

Page 2

Item ID: D206-559-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Series/407 Bearpaws

Start Date: 4/12/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							DAS 66 9-89
Packaging	Identify and pack for shipping as per PPPD206-559-013 Location: <u>013</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

2 MAY 07 2015MLJ MAY 07 2015ME
15-5-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Tuesday, April 21, 2015 1:57:05 PM

Page 1

Work Order ID: 131929

131929

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series/407 Bearpaws

Start Date: 4/12/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A *AN4-17A* Bolt		Purchased		No		160	Each	257.0000	12 **	24		DAS 27 9-89	DAS 26 9-89

Location	Loc Qty	Loc Code
ST325A	100	
M131800	100	
ST343	157	
M129909	6	
M131139	4	
M131377	147	

AN4-20A *AN4-20A* Bolt		Purchased		No		160	Each	153.0000	12 **	24		DAS 27 9-89	DAS 26 9-89
-------------------------------------	--	-----------	--	----	--	-----	------	----------	----------	----	--	-------------------	-------------------

Location	Loc Qty	Loc Code
GA	51	
116419	51	
ST325A	50	
m131803	50	
ST343	52	
131677	52	

MAY 04 2015

M132189

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 131929

Parent Item: D206-559-013

Parent Item Name: 206L Series/407 Bearpaws

131929

D206-559-013

Start Date: 4/12/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

D2182B

Manufactured No

160 f

609.5680

5

DAS
27
9-89

DAS
26
9-89

~~*D2182B*~~

Rubber Cushion - Black (\$Per Foot)

DAS
06
9-89

6x5" per kit

Location

Loc Qty

Loc Code

ST411

259.568

115189

21.5

128976

238.068

st640

350

130427

350

160 Each

697.0000

24

**

DAS
27
9-89

DAS
26
9-89

D2274

Manufactured No

~~*D2274*~~

Radius Block

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST006

550

127579

530

129934

20

ST012a

135

131031

135

160 Each

15.0000

4

**

DAS
27
9-89

DAS
26
9-89

D2432

Manufactured No

~~*D2432*~~

Bearpaw 19" X 24"

DAS
06
9-89

Location

Loc Qty

Loc Code

PKG

15

127600

1

131061

14

B131907

MAY 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

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Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series/407 Bearpaws

Start Date: 4/12/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

D2438

Manufactured

No

160

Each

148.0000

12

DAS
27
9-89

DAS
26
9-89

D2438

Clamp

**

Location

Loc Qty

Loc Code

ST542

148

128921

32

129944

66

131052

50

12

DAS

06

9-89

D2529

Manufactured

No

160

Each

266.0000

24

DAS
27
9-89

DAS
26
9-89

D2529

Washer

**

Location

Loc Qty

Loc Code

ST008

266

128950

266

24

DAS

06

9-89

D2732

Manufactured

No

160

f

611.5000

5

DAS
27
9-89

DAS
26
9-89

D2732

Rubber Cushion (\$per foot)

**

Location

Loc Qty

Loc Code

ST412

420.5

117118

420.5

ST639

191

117118

191

5

DAS

06

9-89

MAY 04 2015

6XS
Per kit

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, April 21, 2015 1:57:05 PM

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Work Order ID: 131929

131929

Parent Item: D206-559-013

D206-559-013

Parent Item Name: 206L Series/407 Bearpaws

Start Date: 4/12/15

Required Date: 4/20/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

1,277.000

12

24

MS21042L4

Locknut

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

574

m127813

574

ST260a

118

m130799

56

m131803

62

ST305

543

426

426

m128300

8

m130922

97

m131618

12

m132123

24

NAS1149D0463J

Purchased

No

160

Each

5,164.000

24

48

NAS1149D0463J

WASHER

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

5123

M129682

86

M130799

403

~~M132035~~

4634

48

DAS
86
9-89

MAY 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

DART AEROSPACE LTD.

REFERENCE ONLY

DAS D206-559
ES
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X	X						D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2	2						D2435	19" X 16" BEARPAW
							D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438L	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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